Tuesday, 10/30/2007 2:50:26 PM Date: Kim Johnston **Process Sheet** : HINGE BRACKET Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number **Estimate Number** : 12543 : NIA : D35381 P.O. Number Part Number S.O. No. : JA : 10/30/2007 D3538 REV.A This Issue **Drawing Number** Prsht Rev. : 10254N/A Project Number First Issue : MACHINED PARTS **Drawing Revision** : 33968 Previous Run . Material 20 Um: Each : 11/6/2007 **Due Date** Written By Checked & Approved By Comment : Est Rev:A New Issue 06-10.03 EC **Additional Product** Job Number: Machine Or Operation: Seq. #: Description: 6061-T6 Bar 1.25 x 1.25" 1.0 M6061T6B1250X01250 Comment: Qty.: 0.1995 f(s)/Unit Total: 6061\_T6 Bar 1.250" x 1.250 Batch: M : BAND SAW 2.0 BAND SAW Comment: BAND SAW Cut blanks 1.500" long HAAS1 HAAS CNC VERTICAL MACHINING #1 Ò Comment: 1-Machine as per Folio FA651 and Dwg D3538 2-Deburr QC2 4.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 5.0 Comment: SECOND CHECK HAND FINISHING RESOURCE #1\* Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

## Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES								
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>67/12/0</u> 7
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NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:50:26 PM User: Kim Johnston **Process Sheet** Drawing Name: HINGE BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 35454 Part Number: D35381 Job Number: Seq. #: Description: Machine Or Operation: POWDER COATING 7.0 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	Ltd					•				
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35454
Description: Hinge Bracket	Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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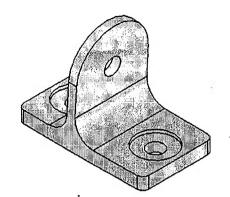
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.375	+/-0.010	-375				
0.241	+/-0.010	.243				
0.830	+/-0.010	.829			-	
Ø0.172	+0.005/-0.001	.173				
Ø0.400	+0.006/-0.001	.399				
0.031	+/-0.010	. 03/				
1.31	+/-0.030	1.315	_	•		
0.375	+/-0.010	.37	(6)			
0.99	+/-0.030	.993				
0.125	+/-0.010	125				
R0.19	+/-0.030	R. 190				
0.083	+/-0.010	.083				
93°	+/-0.5°	930				
0.674	+/-0.010	.677				
R0.38	+/-0.030	.380				
Ø0.172	+0.005/-0.001	172				

Measured by:	SF	Audited by:	J.L.	Prototype Approval:	N/A
Date:	07/12/02	Date:	ONIROZ	Date:	N/A

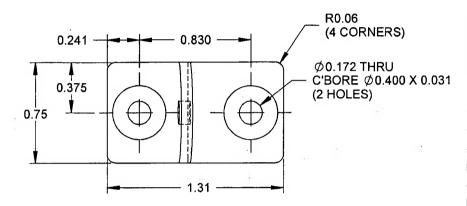
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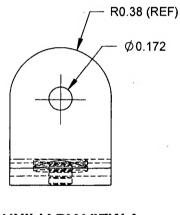


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CHECK	KED	APPROVED	DRAWING NO.	REV. A
1 6	PH	-#	D3538	SHEET 1 OF 2
DATE			TITLE	SCALE
	06.1	0.13	HINGE BRACKET	1:1
REV		DATE	DESCRIPTION	
Α		06.10.13	NEW ISSUE	

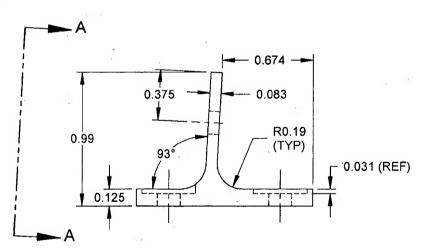


# RELEASED









### D3538-1 HINGE BRACKET

SHOP COPY RETURN TO ENGINEERING

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B) NTROLLED COPY
2) FINISH: CHEMICAL CONVERSION COAT PER DART ON COST (18)

SUBJECT TO AMENDMENT 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 WITHOUT NOTICE POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 ÚNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

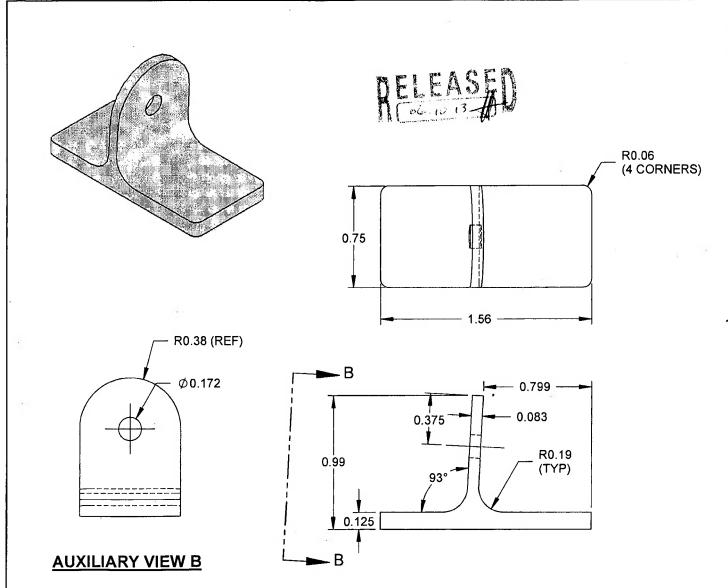
6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED PH	APPROVED	DRAWING NO.	REV. A SHEET 2 OF 2
DATE 06.1	0.13	HINGE BRACKET	SCALE 1:1



### D3538-3 HINGE BRACKET

ENGINEERING

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B) NTROLLED COPY 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

SHOP COPY RETURN TO

SUBJECT TO AMENDMENT WITHOUT NOTICE

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